

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029915**Date Inspected:** 09-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At the Tower Base Electro Slag Weld (ESW) 'V' weld joint #W-043 face B, ABF welder Mike Jimenez was observed continuing to perform the excavation of the ESW at located at Y=5210mm to Y=5225mm due to UT detected rejects. The welder was noted using a die grinder to grind smooth the excavation after using the carbon air arc gouging. This excavation was performed per the approved Request for Weld Repair RWR#201305-009. ABF QC Bernie Docena was noted on site monitoring the excavation. After the excavation and grinding of the surface was completed, ABF QC Bernie Docena performed the test using Magnetic Particle Testing (MT). The result of the QC MT was deemed acceptable according to QC. This QA also performed the same test for the verification of the removal of all the indications and noted same results.

After the QA and QC acceptance of the excavation mentioned above, QA randomly observed the ABF welder Mike Jimenez perform 3G SMAW repair welding of the Ultrasonic Testing (UT) detected reject on the vertical weld of the ESW. The repair excavation is being welded per the approved Request for Weld Repair (RWR) #201305-009. The welder was observed welding in the 3G (vertical) position utilizing the Shielded Metal Arc Welding (SMAW) process with the 3/32" followed by the 1/8" diameter E7018H4R electrode as per the welding procedure ABF-WPS-D15-1000-R03 Repair. The repair excavation and the adjacent base metal were preheated to more than 350°F using Miller Proheat 35 Induction Heating System prior to and during the welding. During this shift, ABF QC William Sherwood was noted monitoring the workmanship and welding parameters of the welder.

